

Work Order ID 47935A

Page 1

Friday, June 26, 2009 9:00:31 AM

Item ID: D2724-042

Accept



Setup Start



Revision ID: C

Item Name: 206L Step Assembly

Stop



Start Date: 7/15/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 8/3/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2724	Rev C								

100



Large Fab

0.00

Large Fab

Memo

0.00

Large Fab

Cut D2724-2 using D2622 extrusion as per Dwg D2724 □ Deburr and bevel ends
for weldingB# 46910

SAD 09-07-01 ④

110



Large Fab

0.00

Large Fab

Memo

0.00

Large Fab

Weld end cap and lugs as per Dwg D2724 using Jig DT8898 followed by Jig
□
DT (One End Only) □ A/R AL ROD Batch: M110130 □ Grind
end cap welds flush1
09-01-14

120



QC9- Inspect visual per QSI004- Fusion Welds

0.00

Quality Control

Memo

0.00

10
09-07-14

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop


**Sequence ID/
Work Center ID**
**Operation
Description**
Set Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

=7

809/07/14 X7AH

P

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

0.00

H 09.07.14 4

150



QC

Quality Control

QC3- Inspect Part Finish

0.00

0.00

SAD 09-07-14 4

4

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Cust Item ID:

Required Date: 8/3/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



Large Fab

Large Fab

Memo

0.00

Large Fab

Inspect for foreign object per QSI 024 □ Weld Remaining end cap as per Dwg D2724 using Jig DT8898 followed by Jig □ DT □ A/R AL ROD
 Batch: M110130 □ Grind end plate flush.

170



QC9- Inspect visual per QSI004- Fusion Welds

0.00

QC

Quality Control

Memo

0.00

PJ 09.07.14

180



QC5- Inspect part completeness to step on W/O

0.00

QC

Quality Control

Memo

0.00

=> 502|07|15 (44) DM

Work Order ID 47935A

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Item Name: 206L Step Assembly

Start Date: 7/15/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 8/3/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start
	QC:	Date:	SPC (Y/N):	Date:	Stop	



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 	Chemical Conversion Coat per QSI005 4.1	0.00	Umo	09/07/15	(X4)				
HandFinish 	Memo	0.00							

Hand Finishing

200



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Pressure Wash Umo 09/07/15 (X4)

Memo

0.00

START TIME: 2:45pm OVEN TEMPERATURE:

FINISH TIME: 3:15pm 320°F

all 09-09-15 X4 H

210



QC

Quality Control

QC3- Inspect Part Finish

0.00

BL 09-07-16 (4)

0.00

Work Order ID 47935A

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Friday, June 26, 2009 9:00:31 AM

Item ID: D2724-042

Accept



Setup Start



Revision ID: C

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Item Name: 206L Step Assembly

Start Date: 7/15/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 8/3/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center ID

220



HandFinish

Operation
Description

Pressure Wash per QSI005.4.3

Wing Walk 09/07/15

Memo

Set Up/
Run Hours

0.00

Draw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Hand Finishing

Batch: m111013

MD 09/07/16 (X)

230



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

BL 09-07-16 0.00 (4).

240



Packaging

Identify as per dwg & Stock Location: _____

0.00

Memo

0.00

PPP 47935 09/07/21 5d (4c)

Work Order ID 47935A

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Friday, June 26, 2009 9:00:31 AM

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Item Name: 206L Step Assembly

Start Date: 7/15/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 8/3/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

250



QC21- Final Inspection - Work Order Release

0.00

09607/22

QC

Quality Control

Memo

0.00

MF 09-07-22

Picklist Print

Page 1

Friday, June 26, 2009 9:00:31 AM

Work Order ID: 47935A



Parent Item: D2724-042RevC



Parent Item Name: 206L Step Assembly

Start Date: 7/15/2009

Required Date: 8/3/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

D 206-608-022

Date: Wednesday, 13/05/2009 11:29:00 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 206L/407 STEP ASSY, RH			
Job Number	: 47935A						
Estimate Number	: 11703						
P.O. Number	:			Part Number	: D2724042		
This Issue	: 13/05/2009	S.O. No.	: :	Drawing Number	: D2724 REV C		
Prsht Rev.	: NC			Project Number	: N/A		
First Issue	: / /		Type	: LARGE FAB ASSY			
Previous Run	: 43032A			Drawing Revision	: C		
Written By	:			Material	:		
Checked & Approved By	: JUD 09-05-03			Due Date	: 29/05/2009		
Comment	: Est Rev:E As Per Ecn 766 06-01-06 JLM				Qty: 4 Um: Each		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	/ D2622120C	Step Extrusion	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Qty Part # Description Batch: 1 D2622-120C Extrusion <u>B26910</u>			
Check Material for any Dents or Defects SAO 09-07-01			
2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	
Comment: LARGE FABRICATION RESOURCE 1 Cut D2724-2 using D2622 extrusion as per Dwg D2724 Debur and bevel ends for welding			
3.0	/ D2734	Step End Plate	
Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s) 206 Step Endplate Pick: Qty Part Number Description Batch 2 D2734 End Cap <u>343535</u>			
4.0	/ D34581	Step Mounting Plate	
Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s) Pick: Qty Part Number Description Batch 2 D3458-1 Plate <u>344002</u>			

Date: Wednesday, 13/05/2009 11:29:00 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L/407 STEP ASSY, RH

Job Number: 47935A

Part Number: D2724042

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	D34583	Step Mounting Plate
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3458-3	Plate	344003

47935A-12

6.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
-----	-------------	------------------------------



Comment: LARGE FABRICATION RESOURCE 1

Weld end cap (One End Only) and lugs as per Dwg D2724 using Jig DT8898 followed by Jig
A/R AL ROD Batch: *m110130*

m110992

47935A-14

Grind end cap welds flush

47935A-14

7.0	QC9	VISUAL WELDING INSPECTION
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Comment: VISUAL WELDING INSPECTION

47935A-14

8.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

47935A-14

9.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

47935A-14

10.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

47935A-14

11.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

47935A-14

Inspect for foreign object per QSI 024

Weld Remaining end cap as per Dwg D2724 using Jig DT8898 followed by Jig

47935A-14

Date: Wednesday, 13/05/2009 11:29:00 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L /407 STEP ASSY, RH

Job Number: 47935A

Part Number: D2724042

Job Number:



Seq. #: Machine Or Operation:

Description :

DT
A/R AL ROD Batch: M110130

Grind end plate flush.

K 09-07-14

12.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

10 09-07-15 (4)

13.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09-07-15 (4) PTO

14.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch up Alodine

(100) 09/07/15 (X4)

15.0 POWDER COATING POWDER COATING



M112148

Pressure Wash

100 09/07/15 (X4)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: 2:45pm

OVEN TEMPERATURE: 320°

FINISH TIME: 3:15pm

21

09-07-15 (X4)

16.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR 09-07-16 (4)

17.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



M11013

Comment: Wing Walk as per Dwg D2724 and QSI 00 5 4.4

100 09/07/16 (X4)

18.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR 09-07-16 (4)

Date: Wednesday, 13/05/2009 11:29:00 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L /407 STEP ASSY, RH

Job Number: 47935A

Part Number: D2724042

Job Number:



Seq. #: Machine Or Operation:

Description :

19.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

20.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

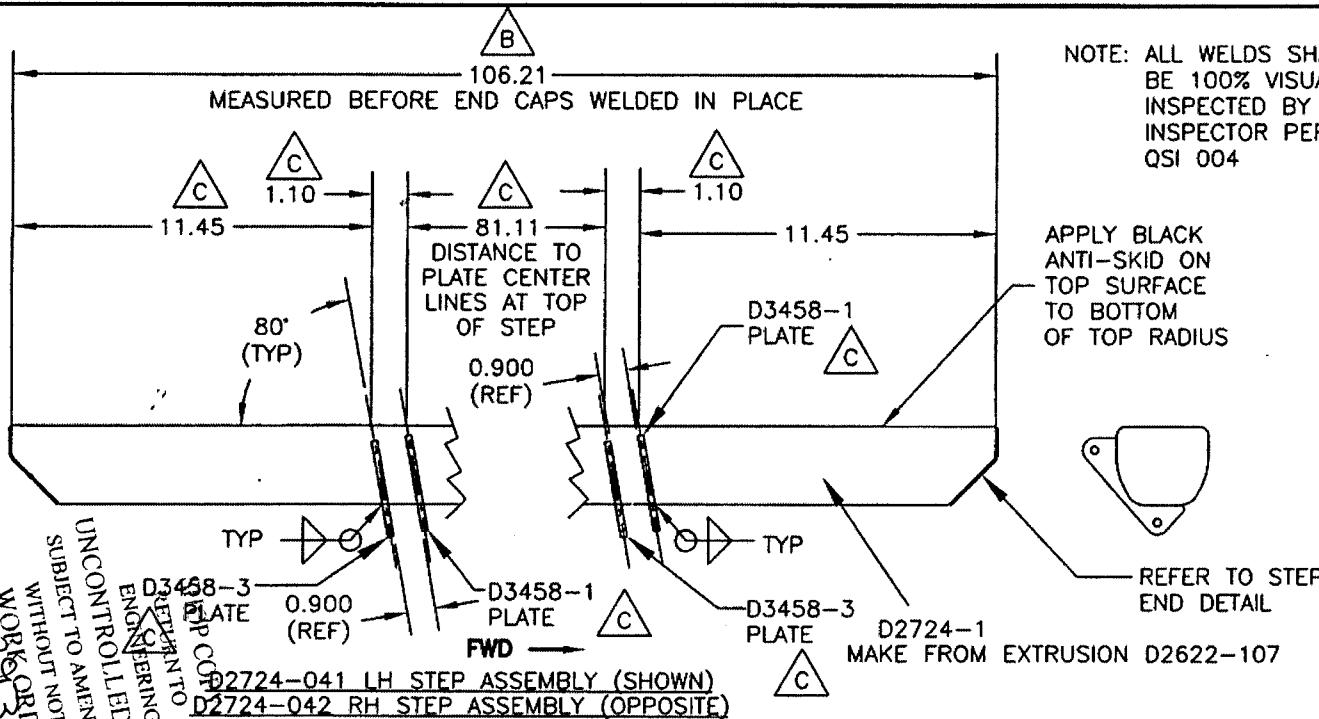
Job Completion



DART

RELEASED
05.09.14

NOTE: ALL WELDS SHALL
BE 100% VISUALLY
INSPECTED BY A QUALIFIED
INSPECTOR PER DART
QSI 004

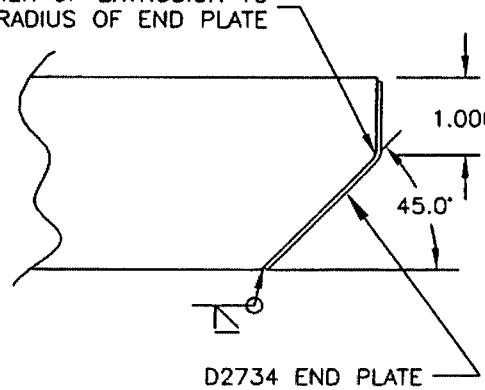


QTY	QTY	PART NUMBER	DESCRIPTION
-041	-042		
X		D2724-041	LH STEP ASSEMBLY
	X	D2724-042	RH STEP ASSEMBLY
1	1	D2622-107	EXTRUSION
2	2	D2734	END PLATE
2	2	D3458-1	PLATE
2	2	D3458-3	PLATE

D2724-041/-042 STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

TYPICAL STEP END DETAIL
NOT TO SCALE



DESIGN KE	DRAWN BY PH	DART AEROSPACE USA, INC.
CHECKED <i>M</i>	APPROVED <i>M</i>	DRAWING NO. D2724
DATE 05.09.19		SHEET 1 OF 1
A	97.12.04	TITLE 206L/407 STEP ASSEMBLY
B	98.10.19	REV. C UPDATED WELD DETAIL REVISED TOLERANCES
C	05.09.19	SCALE N/A RE-DESIGN, ADD D3458-1/-3